

Work Order ID 148661

Wednesday, July 06, 2016 8:38:59 AM

148661

Page 1

Item ID: D3584-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 6/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/5/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 08 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3584	B

100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.13							
Skidtubes	1-Cut to Lengh as per Dwg D3584 2-Drill Pillot Holes using DT8960 Drill Jig 3-Open pillots to 1.000" as per Dwg D3584 4-Deburr								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									

120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.13							
Hand Finishing									

RL. 4 16-08-15

4 8 16-08-23

(x4) 16/09/02
BEB

DAS
18
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 148661

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148661

Page 2

Item ID: D3584-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web

Start Date: 6/28/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-89
130	QC7-Inspect Chemical Conversion Coat	0.00				4	0	16-09-08		
130										
QC	Memo	0.01								
Quality Control										
140	Identify as per dwg & Stock Location: <u>LG002</u>	0.00				4	0	BE 16-09-08		
140										
Packaging	Memo	0.01								
Packaging	LOCATION : LG002									
150	QC21- Final Inspection - Work Order Release	0.00								
150										
QC	Memo	0.07								
Quality Control										

DAS
21
9-89

SEP 09 2016

DAS
21
9-89

SEP 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

Wednesday, July 06, 2016 8:38:58 AM

Page 1

Work Order ID: 148661

148661

Parent Item: D3584-1

D3584-1

Parent Item Name: Web

Start Date: 6/28/2016

Required Date: 7/5/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125		Manufactured	No			110	Each	38.0000	1	4			
D2963-125									**				
105 I Beam Extrusion													

16 - 08-15

Location

Loc Qty

Loc Code

HALL

38

115870

38

R.L

4

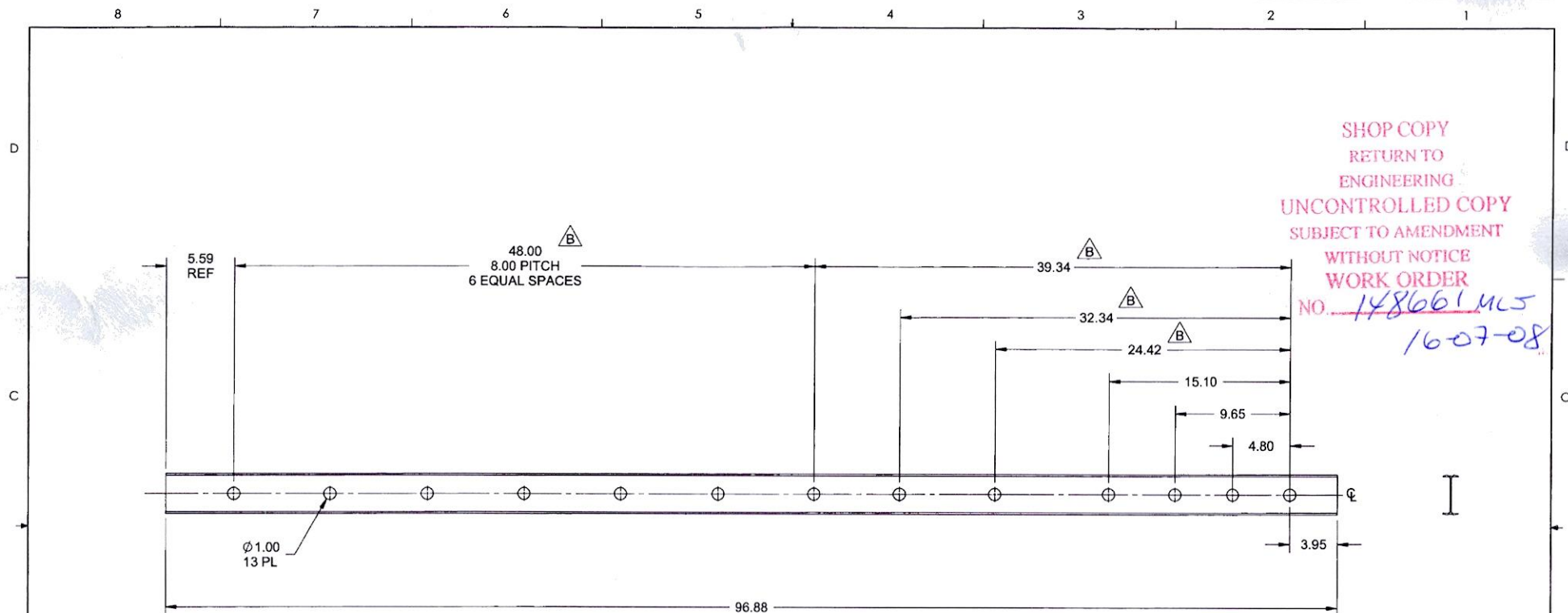
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QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					



D3584-1 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 148661 MJS
1607-08

RELEASED
2015-06-08
ECN 15-651

NOTES:

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.08 lbs

B	24.42 WAS 23.42, 32.34 WAS 31.34 & (48.00 WAS 56.00 (ZN C3-1 & C8-1); ADDED 39.34	RF	15.02.20
A	NEW ISSUE	PH	07.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3584	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	15.02.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED